

# Work Order ID 84803

May-23-12 11:31:43 AM

\*84803\*

Page 1

Item ID: D2432

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: 206 (24") Bearpaw

Start Date: 23/05/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/23

Tooling:

Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2432

Rev F3

(20)

120

0.00

\*120\*

FLOW WATER JET

*[Handwritten signature]*

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

B12-6-2

130

0.00

\*130\*

HAAS CNC VERTICAL MACHINING #1

*[Handwritten signature]* 12/07/01

(x20)

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio and Dwg D2432 Identify as D2432F  
3-Deburr

B12-6-2

140

0.00

\*140\*

QC2- Inspect parts off machine FAI/FAIB

*[Handwritten signature]* 12/07/01

(x20)

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84803

**\*84803\***

Page 2

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Item ID: D2432

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Revision ID:

Item Name: 206 (24") Bearpaw

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Start Date: 23/05/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC8- Inspect parts - second check

0.00

**\*150\***

QC

Memo

0.00

Quality Control

151 Identify as per dwg & Stock Location: \_\_\_\_\_ 0.00

**\*151\***

Packaging

Memo

0.00

Packaging

190 QC21- Final Inspection - Work Order Release 0.00

**\*190\***

QC

Memo

0.00

Quality Control

*mf 12/07/03*

*20*

*CF 12/7/9 (20)*

*CF 12/7/9*

*MF 12-07-04*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

May-23-12 11:31:46 AM

Page 1

Work Order ID: 84803

\*84803\*

Parent Item: D2432

\*D2432\*

Parent Item Name: 206 (24") Bearpaw

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 20.00

Required Qty: 20.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

53.2100

3.7

74

82.

\*MUHMWB10\*

UHMW 1" Black

\*\*

B12-6-2

### Location

### Loc Qty

### Loc Code

MAT018

30.1

120972

3

121346

27.1

MAT019

1.5

118814

1.5

ST052

21.60999474

121277

12.8

121278

8.80999474

121851

121851

20

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	84803
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2432
<b>Inspection Dwg:</b> D2432	<b>Rev:</b> F3	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.064 x 45°	✓		SLO8	Vern
B	5.500	+/-0.030	5.502	✓			
C	0.200	+/-0.030	.199	✓			
D	0.25 x 45°	+/-0.030	.250 x 45°	✓			
E	R0.250	+/-0.030	R.250	✓			
F	0.250	+/-0.010	.253	✓			
G	0.625	+/-0.030	.630	✓			
H	0.375	+/-0.010	.380				
I	0.950	+0.030/0.010	.967	✓			
J	19.000	+/-0.030	19.005	✓		Tape	
K	3.14	+/-0.030	3.125	✓		SLO8	Vern
L	3.28	+/-0.030	3.310	✓			
M	Ø0.260	+0.005/-0.000	Ø.260	✓			
N	Ø0.93	+/-0.030	Ø.927	✓			
O	0.30	+0.030/-0.000	.308	✓			
P	23.750	+/-0.030	23.745	✓		Tape	
Q	7.375	+/-0.030	7.375	✓		SLO8	Vern
R	4.250	+/-0.010	4.251	✓			
S	2.000	+/-0.030	1.9955	✓			
T	9.000	+/-0.010	9.000	✓			
U	9.000	+/-0.010	9.000	✓			
V	0.375	+/-0.010	.385	✓			

<b>Measured by:</b>	JS	<b>Audited by:</b>	gml	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	12/06/30	<b>Date:</b>	12/07/03	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

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**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

NOTICE  
ORDER  
NO. 24803

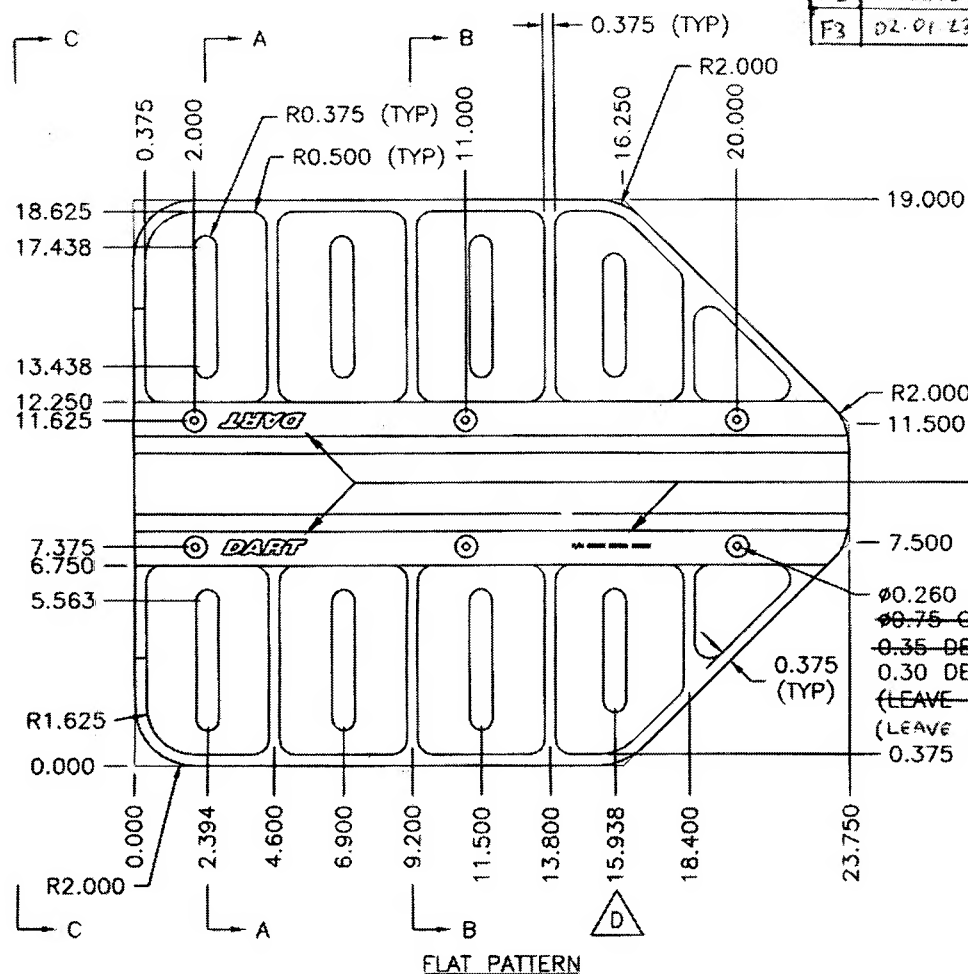
12/05/22



RELEASED  
98.06.17 KE

F1	99.03.02	ADD DEO 9143
F2	01.03.28	<del>0.013 WAS 0.075</del> <del>RF</del>
F3	02.01.23	CLARIFY BORE DIMS <del>RF</del>

ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)



0.260 (TYP)  
~~0.75 C'BORE~~ ~~0.93 C'BORE~~  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)  
(LEAVE 0.650 MIN.)  
0.375

EFFECTIVE	DEOS
9143	

D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	MM	D2432
DATE	TITLE	SHEET 1 OF 2
98.05.12	BEARPAW	SCALE 1:1
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

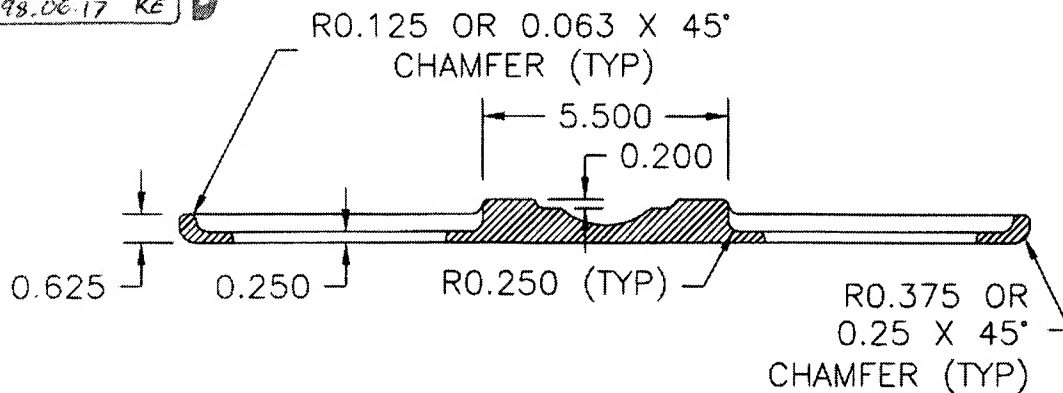
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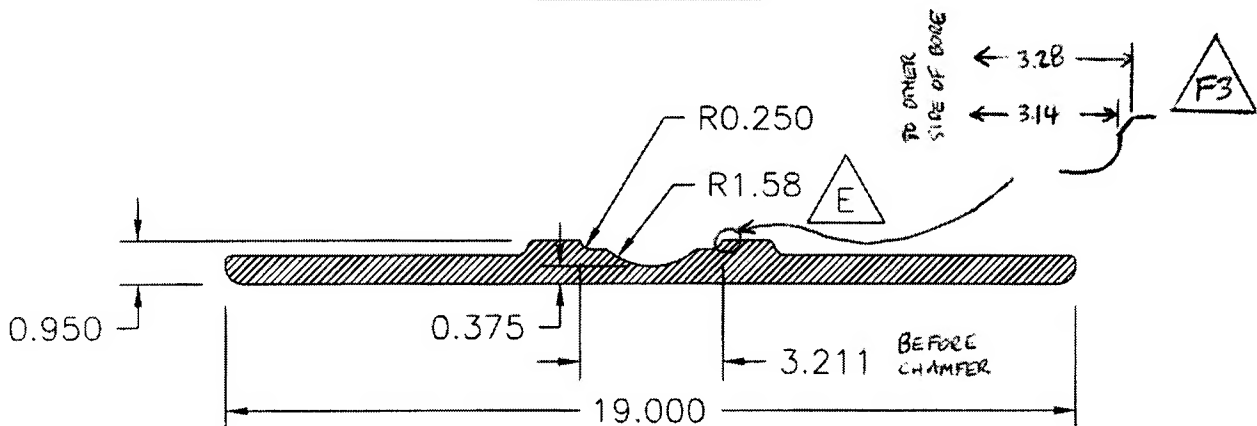


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MA</i>	APPROVED <i>MA</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

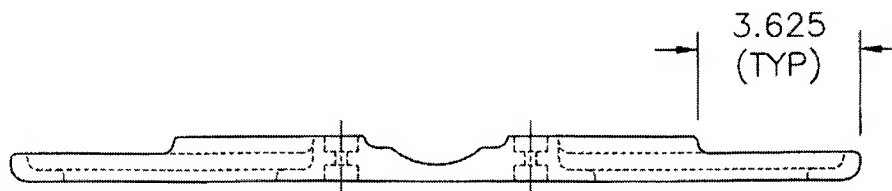
RELEASED  
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

24803

W/O:		WORK ORDER CHANGES					
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